

Work Order ID 152964

Monday, November 07, 2016 4:07:24 PM

152964

Page 1

Item ID: D3697-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tube Assembly
Start Date: 10/31/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 11/7/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **NOV 09 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3697	Rev B								

130

130

Large Fab

Large Fab

Large Fab

Memo

1- cut at 72.00" as per dwg D3697

2- form and trim tube as per dwg D3697 using DT90033-deburr

3-weld D3697-3/-4 and D3797-1 on tube D3697-1 as per dwg D3697 using DT9003 welding jig

4-drill holes in tube in 5 pls as per dwg D3697

0.00

2.10

2 **12** **16-11-17**

140

140

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

2 **16-11-15****DAS**
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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150	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
150 QC Quality Control	Memo	0.01				②	16-11-18		
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160 HandFinish Hand Finishing	Memo	0.06				②	0	2016/11/21	BEG
170	QC3- Inspect Part Finish	0.00							DAS 38 9-89
170 QC Quality Control	Memo	0.00				2			NOV 21 2016

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>51337A</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.03							
Quality Control									

NOV 21 2016

16/11/21 JJ

DAS 21 9-89

NOV 21 2016

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Picklist Print

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Parent Item: D3697-041

D3697-041

Parent Item Name: Tube Assembly

Start Date: 10/31/2016

Required Date: 11/7/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-04-25 new issue DD verified by:EC
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3697-3 *D3697-3* Support Plate, LH		Manufactured	No			130	Each	5.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA002		5							
				<u>145710</u>		5							
D3697-4 *D3697-4* Support Plate, RH		Manufactured	No			130	Each	6.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA002		6							
				<u>147795</u>		5							
				84844		1							
D3797-1 *D3797-1* Ground Plate		Manufactured	No			130	Each	3.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		3							
				<u>145604</u>		3							
M6061T6T0.375W.049 *M6061T6T0 375W 049* 6061-T6 RD Tube .375 x.049W		Purchased	No			130	f	130.6300	6	12.63158			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT013		130.63							
				<u>121910</u>		108							
				122147		22.63							

DQA: _____ Date: _____



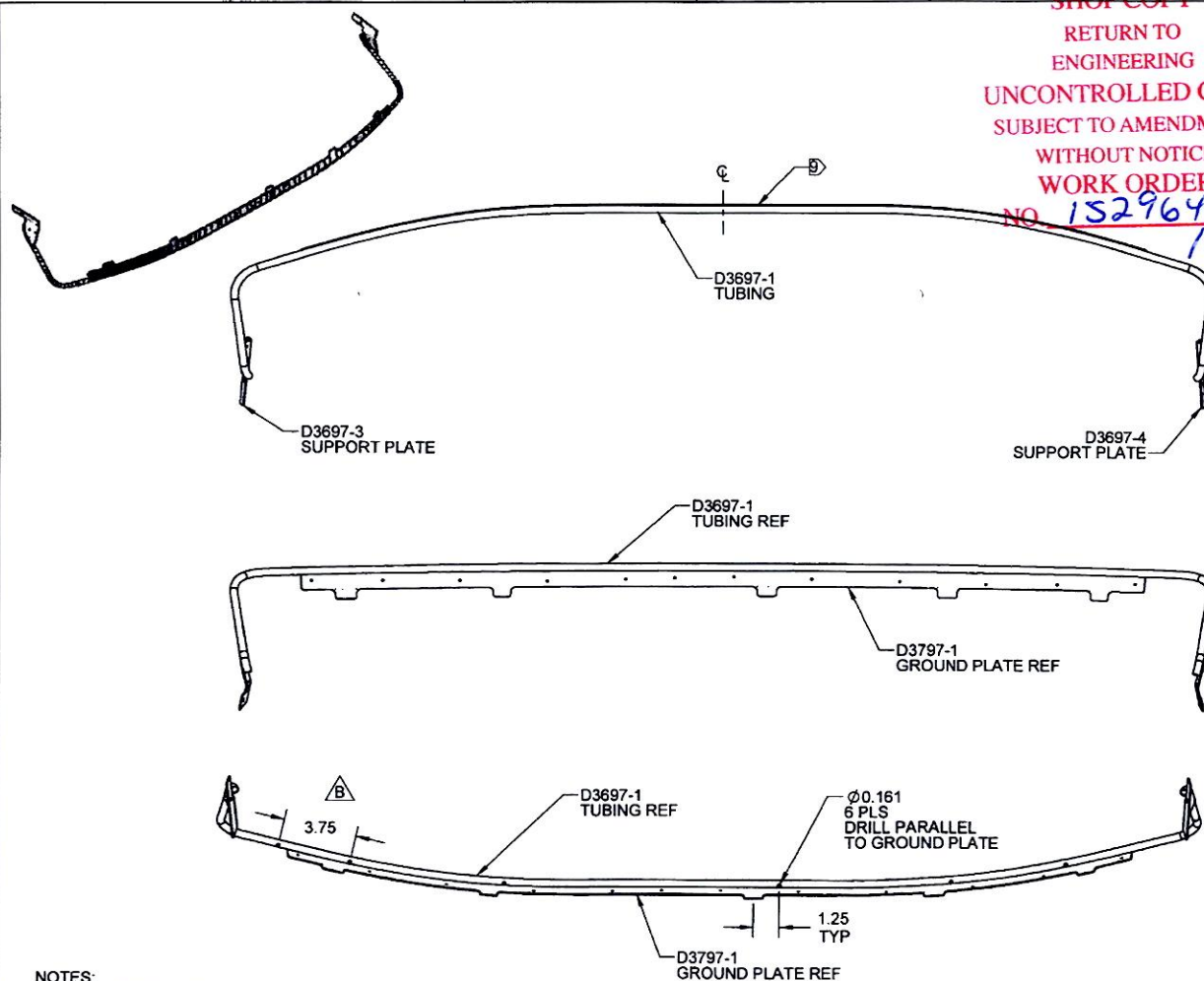
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OTHER : _____					

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152964 MLW
16-11-09



NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.55 lbs
- 8) LOCATE D3697-3/4 ON D3697-1 USING DT9009 WELDING JIG
- 9) CENTER D3797-1 GROUND PLATE ON D3697-1 TUBING

D3697-041 TUBE ASSEMBLY

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3697-041	TUBE ASSEMBLY
1	D3697-1	TUBING
1	D3697-3	SUPPORT PLATE
1	D3697-4	SUPPORT PLATE
1	D3797-1	GROUND PLATE

B	REMOVE POWDER COAT & MASKED HATCHED AREAS SHEET 1 ZONE A.6; ADD Ø0.161 HOLE. SHEET 1 ZONE B.7	RF	08.06.02
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV.
MFG. APPR.	<i>[Signature]</i>	D3697	SHEET 1 OF
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE ASSEMBLY	NT
DATE	08.06.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	